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(54) **VALVE**

**DICHTUNG**

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## Description

[0001] The invention relates to a valve and to a method of assembling such a valve. In particular the invention is related to improvements for the type of valve known in the trade as a double block or a double block with bleed valve (hereinafter both referred to as a double block valve). This type of valve is used in pipelines as an isolation valve and comprises first and second ball valve assemblies in an in line configuration. The provision of the two ball valve assemblies means that if one of the assemblies fails there is still another valve assembly operational.

[0002] The double block valve is commonly connected to pipelines in process, oil and gas and instrumentation industries such as refineries for carrying compressible, incompressible, or combinations of these fluids. The use of the valve is well known in the trade and can be provided to allow safe isolation of parts of the pipeline to allow repair or maintenance work and/or the connection of monitoring and/or injection apparatus. The valve is normally provided with a vent facility which is located between the two valve assemblies so as to allow for the controlled venting of the fluid carried in the pipeline and the collection of samples

[0003] There are many different designs of double block valve assemblies but generally they comprise a valve body in which the valve components are held, with a vent formed therein. The valve body is provided with a passage therethrough, and into said passage, and from each end thereof, are fitted the respective valve assembly components of the ball, seats and seals. When the components are fitted into the passage from each end, the components are locked in position by the insertion of retaining members into each end of the passage. This design of valve has been used for a considerable period of time but has several disadvantages, in that the valve is relatively long and bulky and also that the valve has at least two joints where leakage or failure of the valve can occur. In the example described the joints are created between the retaining means inserted at each end of the passage, at which failure and leakage can occur. It is accepted that the greater the number of joints in the valve then the greater the risk of leakage occurring and, when one considers that the fluids being carried can be hot, toxic, corrosive and/or combustible, it will be appreciated that any leakage can be catastrophic.

[0004] GB-A-2271164 discloses an arrangement for a double block valve where there is provided a sealing element which is inserted into the valve body and which acts as a common element for both of the ball valve assemblies. This is claimed to reduce the overall length of the double block valve assembly. However the valve according to this patent still has at least two joints at which leakage can occur, these being between each of the assemblies and the intervening common valve seat.

[0005] GB2064730 describes a butterfly valve ar-

range having a pair of rotateable flaps internally of the valve which are operated by a single actuation means and close simultaneously. A venting arrangement is provided in conjunction with the flaps such that the venting arrangement is opened to allow for drainage when the two flaps and thus the valve is closed. The valve is stated as being for the food and drinks industries, and is insubstantial in that a significant fluid pressure build up behind either of the flaps may burst same causing catastrophic failure.

[0006] DE3339472 discloses a valve consisting of two independently operable ball valves encased within a single housing and further having an adjustable resilient elastomeric member between and contacting the ball valve assemblies to create a seal therebetween. The resilient member is elongated between the ball valves to compress same by means of driving one or more arrow-headed members transversally into the member to deform same longitudinally. The valve is not formed from two separable assemblies, and cannot therefore be used in the gas and oil industries.

[0007] US4335747 describes a valve having two rotateable ball valves housed in separate assemblies, one of said ball valves being substantially spherical and the other being generally spherical but having a spherically arcuate recess which receives a portion of the other substantially spherical ball valve. In the closed condition, the partially spherically shaped ball valve is prevented from being rotated by the spherically shaped ball valve, and therefore not only is the operation of the ball valves dependent on one another, the removal of one of the assemblies will affect the integrity of the remaining assembly because in the closed condition, one ball valve provides support for the other.

[0008] The aim of the present invention is to provide a double block valve in which the risk of leakage and failure of the same is minimised without unduly affecting the length of the same or affecting any of the other characteristics of the same and ensuring that the valve meets the appropriate safety and manufacturing standards.

[0009] In a first aspect of the invention there is provided a valve comprising a first ball valve assembly and a second ball valve assembly, each being self-contained and each of said first and second ball valve assemblies having a passage therethrough in which a first seal, an apertured ball valve and a second seal are disposed, said ball valves being independently actuatable between open and closed positions to allow fluid flow through the valve when both ball valves are in the open condition, characterised in that said first and second ball valve assemblies further comprise apertured retainer components lockingly inserted into each assembly to retain the ball valve component and first and second seals in each assembly and in that the assemblies are connected together to mate with one another with their respective passages substantially in alignment to form the valve with only a single joint. In one preferred embodiment

ment the first and second ball valve assemblies are provided as contained modules which are brought together and held in position so as to form the said valve with the single joint at the interface of the said two modules.

[0010] In one preferred embodiment the assemblies are engaged in location by means of external locking means.

[0011] Typically each ball valve assembly is a self contained module. In one embodiment the module comprises a body with a passage formed therethrough said passage having a narrow end and a relatively wider end through which the components of the valve can be packed into the body, said components being the first seal, the ball valve, the second seal and the retainer. The retainer is typically inserted into engagement with the wider end of the passage once the first seal, ball and second seal are inserted into the passage and serves to hold the components in the passage and has an aperture therethrough to complete the passage through the body.

[0012] Typically the retainer is held in engagement with the body by providing threaded portions on the retainer and passage which allows the retainer to be screwed into position and also to exert any required packing force on the ball and seals against the narrower end of the passage.

[0013] To form the valve according to the invention, two of the ball valve modules are brought into mutual position such that the outer faces of the retainers, which in one embodiment lie flush with the outer face of the respective assembly bodies, are held adjacent one another with the respective passages in line, and then the assemblies are engaged in that position to form the double block valve.

[0014] It will therefore be appreciated that the only joint in the valve according to the invention is that between the adjacent end faces of the two modules.

[0015] Typically each of the valve assemblies includes a ball actuation means to allow the valve to be moved between open and closed positions. In one preferred embodiment a packing retainer is provided for the packing in the actuation means stem and said packing retainer is locked in position by means of a cam headed locking screw which is positioned adjacent a flat of the packing retainer and the cam secured in position so as to prevent accidental removal of the packing or loosening due to vibration or other means.

[0016] Preferably the stem is provided of a shape and dimension so as to allow low emission type packing to be used such as, for example, the packing sold under the trade mark Enviroflex, a trade mark of Flexitell Ltd.

[0017] Thus according to the invention there is provided a modular valve formed from two valve assembly modules held in engagement, each module a self contained valve assembly.

[0018] The valve formed according to this invention allows one of the modules to be removed for repair or

maintenance without affecting the integrity of the other valve module. This is not possible with conventional valves of this type.

[0019] A further preferred feature of the valve according to this invention is that a single body seal lies within the joint between respective assemblies to prevent leakage of fluid through the joint. Typically the body seal will have a continuous surface between the end faces of the valve modules which form the single joint. One suitable body seal is a metallic lens ring such as that sold under the trade mark Techlok.

[0020] In a preferred embodiment there is provided a further seal assembly which comprises a sealing element located between the retainers in the assembled valve, said sealing element acting to prevent the leakage of fluid from the passage of the valve into the joint between the retainers.

[0021] In a further preferred aspect of the invention the valve includes a locking means which is located between the end faces of the retainers of respective valve assemblies when the valve is assembled, said locking means positioned such that relative movement of the retainers within the valve when formed is prevented.

[0022] Typically the locking means is a ring which is formed of a material which preferably has a higher degree of resilience than the body seal so as to allow compression of the locking means prior to the body seal and hence act as a means to absorb vibration or other forces on the retainers from causing the same to move position in the valve. This ensures that the unscrewing or loosening of the same during the service of the valves is prevented. This locking assembly can also be provided as the sealing element to prevent crevice erosion occurring and can be used in any double block valve, even with multiple joints.

[0023] In whichever embodiment of the invention the valve is typically provided with a vent assembly. Said vent assembly is provided to be operated from externally of the valve body and is in connection with the valve passage.

[0024] In one embodiment the vent assembly is connected to one of the valve modules and forms an integral part thereof. In an alternative embodiment the vent assembly can be located in a member inserted to lie between the modules when joined to form the valve. It is however preferred that the vent arrangement takes the form as shown wherein the vent assembly is connectable with one of a plurality of apertures formed in the passage wall. This connection can be a direct connection or alternatively the apertures can be connected to a common chamber to which the vent assembly or assemblies can be connected in the required location on the valve. This is described in the applicant's co-pending patent application.

[0025] In a yet further aspect of the invention there is provided a method of assembling a double block valve according to the invention, said method comprising the steps of forming a first ball valve assembly by forming

a body having a passage, end of which is of sufficient diameter to allow the valve components to be moved into the passage, inserting said components which comprise a first seal, an apertured ball valve and a second seal into the passage in the required sequence, trapping the components in the passage by inserting a retainer, engaging the ball with actuating means to allow movement of the ball between open and closed positions, repeating the process to form a second ball valve assembly, bringing the assemblies together so that the end faces in which the retainers are located are adjacent and the passages in respective assemblies are in line and connecting the assemblies together to form the valve, with only a single joint.

[0026] In a preferred embodiment a venting arrangement is fitted to either one of the modules or to a member positioned between said modules when engaged.

[0027] Thus the single joint of this invention is formed between any two major body components which in combination form the said double block valve.

[0028] Thus, a preferred embodiment of the valve can have the double block valve comprising of two full bore valve balls which is compact within the International Standard Lengths dictated by ANSI and others.

[0029] Specific embodiments of the invention will now be described with reference to the accompanying drawings wherein;

Figure 1 illustrates a diagrammatic elevation of a double block valve according to one embodiment of the invention;

Figure 2 illustrates the components of a modular valve assembly according to one embodiment of the invention.

Figures 3A -3D illustrate specific features of the invention in greater detail.

[0030] Referring now to the drawings there is shown a valve 2 according to the invention with the central portion of the passage 4 removed to show the components of the valve in section. The passage 4 passes through the length of the valve 2 and the valve is typically joined to other components such as monitoring instruments and/or a pipeline by means of flanges 6,8.

[0031] The valve shown is known as a double block and vent (bleed) valve and comprises two ball valve assembly modules 10, 12 and a vent assembly 14". The vent assembly is connected to the passage 4 via port 5 and is positioned intermediate the balls of the ball valve assembly modules 10, 12 to allow the controlled venting of fluid from the passage 4 and hence the pipeline.

[0032] The modules 10,12 are each provided with a passage 4A, 4B of larger diameter in which the valve components are located and so the passage ends 4A', 4B' are relatively larger to allow the components to be fitted into the passage when assembled.

[0033] Each valve module, as shown in Figure 2 with respect to module 10, includes a first seal 14 which is first placed in position in the passage 4A and also provides fire retardant features in combination with the second seal 18 as shown in Figure 3D. The ball 16 is then placed in position and is followed by the second seal 18. When these components are in position a retainer 20, with threaded side walls, is screwed into a threaded portion 21 of the passage through end 4A', and this serves to retain the components in position in the passage as shown in Figure 1. The retainer has a central aperture 23 of substantially the same diameter as the passage 4 so as to ensure that there is provided a passage 4 through the valve as required. The same process is repeated for module 12 using components 14'-20'. The retainers 20,20' are provided in a mutual relationship as shown in Figure 3B to act to lock, form, seats for and retain the balls of the ball valves in position.

[0034] Each module is provided with an actuating means 24 in connection with the ball 16, 16' to allow the valve assembly to be moved between open and closed conditions. The actuating means comprises a valve stem 26 (shown in detail in Figure 3A) connected to a packing retainer 28 and a lever 30 to allow actuation. The packing retainer is typically required to be maintained in the closed position to trap the packing in the stem 26, said packing typically low emission packing, and to ensure that the same is not accidentally moved, or influenced by vibration, is locked in position by a cam headed locking screw 32 which contacts with a flat of the packing retainer 28 (see Figure 3C) in such a manner to ensure that the packing retainer cannot be rotated until the cam headed locking screw is first released and removed.

[0035] With each of the valve modules formed, the end faces 4A', 4B' of the same are brought into engagement and as this is done they trap a body seal 38 in position as shown and a sealing and locking means 40 in position as shown. When in position, external retaining means, not shown, act to clamp the two modular valve assemblies together to form the valve according to the invention. It will readily be appreciated that the valve formed only has one joint 42 and so the opportunity for leakage and/or failure to occur is significantly reduced in comparison to the conventional double block valves which have at least two joints.

[0036] A further advantage of the valve according to this invention is that the valve is formed from two modular assemblies, each of which can be disengaged for repair or maintenance without affecting the integrity of the other. This therefore means that a module can be removed, taken for repair in a clean environment and at the same time replaced with another module easily and quickly.

[0037] The valve according to the invention can also be manufactured to meet all relevant International Standards such as ANSI B 16.5, ANSI B16.10, ANSI B 16.34, API 6D, API Spec6FA, API 598, API 607,

BS6755, EEMUA182.

## Claims

1. A valve (2) comprising a first ball valve assembly (10) and a second ball valve assembly (12) each being self contained and each of said first and second ball valve assemblies having a passage (4, 6) therethrough in which a first seal (14, 14'), an apertured ball valve (16, 16') and a second seal (18, 18') are disposed, said ball valves being independently actuatable between open and closed positions to allow fluid flow through the valve when both ball valves are in the open condition, **characterised in that** said first and second ball valve assemblies further comprise apertured retainer components (20, 20') locking inserted into each assembly to retain the ball valve and first and second seals in each assembly and **in that** the assemblies are connected together to mate with one another with their respective passages substantially in alignment to form the valve with only a single joint (42).
2. A valve (2) according to claim 1 **characterised in that** the passages (4, 6) each of said first and second ball valve assemblies (10, 12) have two different diameters, the diameter of the passage at one extremity of the assembly being less than the diameter of the passage at the alternate end thereof, the passages having the larger diameters being in the region of the end of the assemblies which are brought into mating contact.
3. A valve (2) according to claim 2 **characterised in that** the first seal (14, 14') and the second seal (18, 18') of each ball valve assembly (10, 12) is substantially
4. A valve (2) according to any of the preceding claims **characterised in that** each of the first and second valve assemblies (10, 12) are provided with a substantially planar mating surface.
5. A valve (2) according to claim 4 **characterised in that** the apertured retainer component (20, 20') is substantially flush with the mating surfaces of the first and second valve assemblies after complete insertion.
6. A valve (2) according to any preceding claim **characterised in that** the retainer component (20, 20') is provided with threads and is screwed into corresponding threads (21) provided in the wider ends of the passages of said first and second ball valve assemblies.
7. A valve (2) according to any of preceding claim
8. A valve (2) according to any of preceding claim **characterised in that** a seal (38) is provided in an outer surface of at least one of the retainer components, said seal being compressed by the corresponding surface of the alternate retainer component in the alternate ball valve assembly as the two valve assemblies are brought together thus preventing fluid escape through the joint.
9. A valve (2) according to claim 8 **characterised in that** said seal (40) is of resilient material which frictionally resists relative movement of the retainers within the valve when in a compressed condition.
10. A valve (2) according to any of the preceding claims wherein each of the first and second ball valve assemblies (10, 12) includes an actuation means (30) connected to a stem (26) having a packing (28) inserted into the assembly which allows the ball valve (16, 16') to be moved between open and closed positions.
11. A valve (2) according to claim 10 **characterised in that** a cam headed locking screw (32) is provided against a flat of the stem (26) or against a flat of a nut retaining said stem (26) and/or packing (28) to prevent accidental removal of the stem or packing, or loosening thereof due to vibration or other means.
12. A valve (2) according to claims 10-11 **characterised in that** the packing (28) is a low emission type packing such as Enviroflex®.
13. A valve (2) according to any of the preceding claims **characterised in that** a vent assembly (14'') is connected within the valve in communication with the passage (4) between the ball valves (16, 16') of the first and second ball valve assemblies (10, 12).
14. A valve (2) according to claim 13 **characterised in that** the vent assembly (14'') forms an integral part of one or the ball valve assemblies (10, 12).
15. A valve (2) according to claim 13 **characterised in that** the vent assembly (14'') is located in a member inserted to lie between the ball valve assemblies (10, 12) when joined to form the valve.
16. A valve (2) according to claim 13 **characterised in that** the vent assembly (14'') is connectable with one of a plurality of apertures (5) formed in the passage wall.

17. A valve (2) according to claim 16 **characterised in that** the plurality of apertures (5) in the passage wall all communicate with the vent via a communal chamber in which all the apertures open.
18. A valve (2) according to any preceding claim **characterised in that** a locking means (40) is located between the end faces of the retainers of respective valve assemblies when the valve is assembled, said locking means preventing relative movement of the retainers within the valve.
19. A valve (2) according to claim 18 **characterised in that** the locking means (40) is a ring which is formed of a material which preferably has a higher degree of resilience than the body seal (38) so as to allow compression of the locking means prior to the body seal and hence act as a means to absorb vibratory or other forces on the retainers (20, 20') from causing the same to move position in the valve.
20. A method of assembling a double block valve (2) as defined in claim 1, said method comprising the steps of forming a first ball valve assembly (10) by forming a body having a passage (4A), one end of which is of sufficient diameter (4A') to allow the valve components (14, 16, 18) to be moved into the passage (4A), inserting said components which comprise a first seal (14), an apertured ball valve (16) and a second seal (18), inserting an apertured retainer (20) which retains the valve components within the assembly engaging the ball (16) with actuating means (30, 26, 28) to allow movement of the ball between open and closed positions, repeating the process to form a second ball valve assembly (12), bringing the assemblies together so that the end faces in which the retainers are located are adjacent and the passages in respective assemblies are aligned and connecting the assemblies together to form the valve with only a single joint.
21. A method according to claim 20 **characterised in that** a venting arrangement (14) is fitted to either one of the assemblies (10, 12) or to a member positioned between said assemblies when engaged.

#### Patentansprüche

1. Ventil (2), umfassend eine erste Kugelventilbaugruppe (10) und eine zweite Kugelventilbaugruppe (12), die jeweils in sich geschlossen sind, wobei sowohl die erste als auch die zweite Kugelventilbaugruppe einen Durchgang (4, 6) aufweisen, in dem eine erste Dichtung (14, 14'), ein Kugelventil (16, 16') mit Durchbruch und eine zweite Dichtung (18, 18') angeordnet sind, wobei die genannten Kugelventile unabhängig voneinander zwischen einer of-

fenen und einer geschlossenen Position betätigt werden können, um Fluidstrom durch das Ventil zu lassen, wenn sich beide Kugelventile im offenen Zustand befinden. **dadurch gekennzeichnet, dass** die genannte erste und die genannte zweite Kugelventilbaugruppe ferner Haltekomponenten (20, 20') mit Durchbruch aufweisen, die arretierend in jede Baugruppe eingesetzt werden, um das Kugelventil und die erste und die zweite Dichtung in jeder Baugruppe festzuhalten, und dadurch, dass die Baugruppen so miteinander verbunden sind, dass sie ineinander passen, wobei ihre jeweiligen Durchgänge im Wesentlichen aufeinander fluchten, um das Ventil mit nur einer Übergangsstelle (42) zu bilden.

2. Ventil (2) nach Anspruch 1, **dadurch gekennzeichnet, dass** die Durchgänge (4, 6) der genannten ersten und der genannten zweiten Kugelventilbaugruppe (10, 12) zwei verschiedene Durchmesser aufweisen, wobei der Durchmesser des Durchgangs an einem Ende der Baugruppe geringer ist als der Durchmesser des Durchgangs an seinem anderen Ende, wobei sich die Durchgänge mit den größeren Durchmessern im Bereich desjenigen Endes der Baugruppen befinden, die in Paarungskontakt gebracht werden.
3. Ventil (2) nach Anspruch 2, **dadurch gekennzeichnet, dass** die erste Dichtung (14, 14') und die zweite Dichtung (18, 18') jeder Kugelventilbaugruppe (10, 12) im Wesentlichen ringförmig sind.
4. Ventil (2) nach einem der vorherigen Ansprüche, **dadurch gekennzeichnet, dass** sowohl die erste als auch die zweite Ventilbaugruppe (10, 12) mit einer im Wesentlichen planaren Paarungsfläche versehen sind.
5. Ventil (2) nach Anspruch 4, **dadurch gekennzeichnet, dass** die Haltekomponente (20, 20') mit Durchbruch im Wesentlichen bündig mit den Paarungsflächen der ersten und der zweiten Ventilbaugruppe nach einem vollständigen Einfügen sind.
6. Ventil (2) nach einem der vorherigen Ansprüche, **dadurch gekennzeichnet, dass** die Haltekomponente (20, 20') mit einem Gewinde versehen ist und in ein entsprechendes Gewinde (21) eingeschraubt wird, das jeweils in den breiteren Enden der Durchgänge der genannten ersten und der genannten zweiten Kugelventilbaugruppe vorgesehen ist.
7. Ventil (2) nach einem der vorherigen Ansprüche, **dadurch gekennzeichnet, dass** das Ventil mit einer kontinuierlichen Dichtung (38) versehen ist, die die Haltekomponenten des Ventils im Bereich der einzelnen Verbindungsstelle (42) umgibt.

8. Ventil (2) nach einem der vorherigen Ansprüche, **dadurch gekennzeichnet, dass** eine Dichtung (40) in einer Außenfläche von wenigstens einer der genannten Haltekomponenten vorgesehen ist, wobei die genannte Dichtung von der entsprechenden Fläche der anderen Haltekomponente in der anderen Kugelventilbaugruppe komprimiert wird, wenn die beiden Ventilbaugruppen zusammengebracht werden, um so zu verhindern, dass Fluid durch die Verbindungsstelle entweicht.
9. Ventil (2) nach Anspruch 8, **dadurch gekennzeichnet, dass** die genannte Dichtung (40) aus einem elastischen Material besteht, das reibungsmäßig relativen Bewegungen der Halter innerhalb des Ventils widersteht, wenn sie sich in einem komprimierten Zustand befindet.
10. Ventil (2) nach einem der vorherigen Ansprüche, bei dem sowohl die erste als auch die zweite Kugelventilbaugruppe (10, 12) ein Betätigungsmittel (30) aufweist, das mit einem Schaft (26) mit einer Zwischenlage (28) verbunden ist, die in die Baugruppe eingefügt wird, so dass das Kugelventil (16, 16') zwischen der offenen und der geschlossenen Position bewegt werden kann.
11. Ventil (2) nach Anspruch 10, **dadurch gekennzeichnet, dass** eine Nockenkopf-Arretierungsschraube (32) an einem Flachstück des Schaftes (26) oder einem Flachstück einer Mutter vorgesehen ist, die den genannten Schaft (26) hält, und/oder einer Zwischenlage (28), um ein versehentliches Entfernen des Schaftes oder der Zwischenlage oder ein Lösen davon aufgrund von Vibrationen der anderen Mitteln zu verhindern.
12. Ventil (2) nach Anspruch 10-11, **dadurch gekennzeichnet, dass** die Zwischenlage (28) eine Niederemissionszwischenlage wie Enviroflex® ist.
13. Ventil (2) nach einem der vorherigen Ansprüche, **dadurch gekennzeichnet, dass** eine Lüftungsbaugruppe (14'') im Ventil in Verbindung mit dem Durchgang (4) zwischen den Kugelventilen (16, 16') der ersten und der zweiten Kugelventilbaugruppe (10, 12) ist.
14. Ventil (2) nach Anspruch 13, **dadurch gekennzeichnet, dass** die Lüftungsbaugruppe (14'') einen integralen Bestandteil von einer der Kugelventilbaugruppen (10, 12) bildet.
15. Ventil (2) nach Anspruch 13, **dadurch gekennzeichnet, dass** die Lüftungsbaugruppe (14'') sich in einem Element befindet, das so eingefügt wird, dass es zwischen den Kugelventilbaugruppen (10, 12) liegt, wenn es zur Bildung des Ventils verbunden wird.
16. Ventil (2) nach Anspruch 13, **dadurch gekennzeichnet, dass** die Lüftungsbaugruppe (14'') mit einer aus einer Mehrzahl von Durchbrüchen (5) verbunden werden kann, die in der Durchgangswand ausgebildet sind.
17. Ventil (2) nach Anspruch 16, **dadurch gekennzeichnet, dass** die Mehrzahl von Durchbrüchen (5) in der Durchgangswand alle mit der Lüftung über eine Gemeinschaftskammer in Verbindung stehen, in der alle Durchbrüche münden.
18. Ventil (2) nach einem der vorherigen Ansprüche, **dadurch gekennzeichnet, dass** sich ein Arretierungsmittel (40) zwischen den Endflächen der Halter jeweiliger Ventilbaugruppen befinden, wenn das Ventil zusammengebaut wird, wobei das genannte Arretierungsmittel eine relative Bewegung der Halter innerhalb des Ventils verhindert.
19. Ventil (2) nach Anspruch 18, **dadurch gekennzeichnet, dass** das Arretierungsmittel (40) ein Ring ist, der aus einem Material gebildet ist, das vorzugsweise einen höheren Elastizitätsgrad hat als die Körperdichtung (38), um eine Kompression des Arretierungsmittels vor der Körperdichtung zuzulassen und somit als ein Mittel zum Absorbieren von Vibrationen oder anderen Kräften an den Haltern (20, 20') zu wirken, um zu verhindern, dass sich diese aus der Position in dem Ventil bewegen.
20. Verfahren zum Zusammensetzen eines Doppelblockventils (2) gemäß Anspruch 1, wobei das genannte Verfahren die folgenden Schritte umfasst: Ausbilden einer ersten Kugelventilbaugruppe (10) durch Ausbilden eines Körpers mit einem Durchgang (4A), von dem ein Ende einen ausreichend großen Durchmesser (4A') hat, um es zuzulassen, dass die Ventilkomponenten (14, 16, 18) in den Durchgang (4A) bewegt werden; Einsetzen der genannten Komponenten, die eine erste Dichtung (14), ein Kugelventil (16) mit einem Durchbruch und eine zweite Dichtung (18) umfassen, Einsetzen einer Halterung (20) mit Durchbruch, die die Ventilkomponenten in der Baugruppe festhält, In-Eingriff-Bringen der Kugel (16) mit Betätigungsmitteln (30, 26, 28), um eine Bewegung der Kugel zwischen der offenen und der geschlossenen Position zuzulassen, Wiederholen des Vorgangs, um eine zweite Kugelventilbaugruppe (12) zu bilden, Zusammenbringen der Baugruppen, so dass die Endflächen, in denen sich die Halter befinden, benachbart sind und die Durchgänge in jeweiligen Baugruppen aufeinander ausgerichtet sind und die Baugruppen miteinander verbinden, um das Ventil mit nur einer einzigen Verbindungsstelle zu bilden.

21. Verfahren nach Anspruch 20, **dadurch gekennzeichnet, dass** eine Lüftungsanordnung (14) an einer der Baugruppen (10, 12) oder an einem Element montiert wird, das sich im Eingriff zwischen den genannten Baugruppen befindet.

#### Revendications

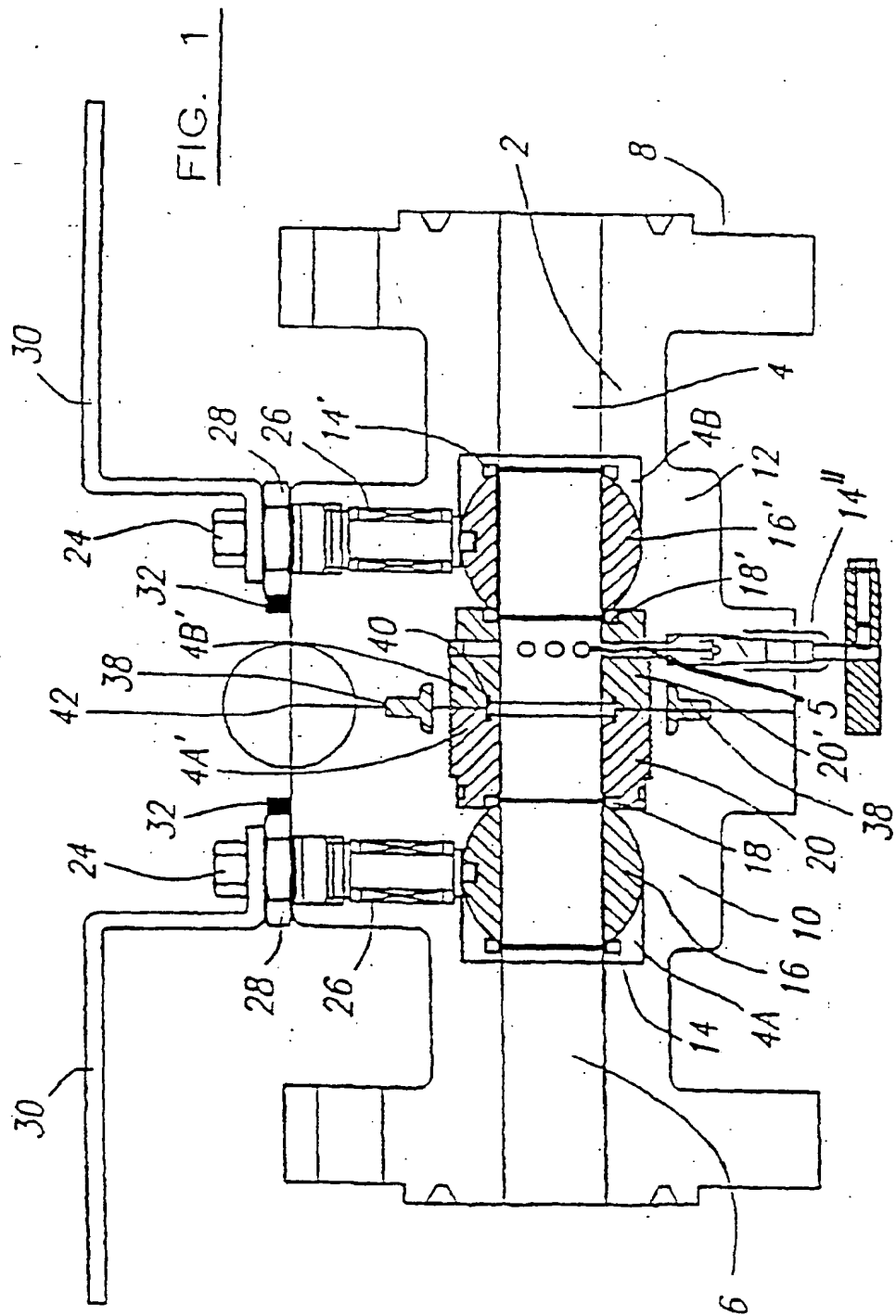
1. Vanne (2) comprenant un premier ensemble de vanne à bille (10) et un deuxième ensemble de vanne à bille (12), chacun étant autonome et chacun desdits premier et deuxième ensembles de vanne à bille possédant un passage traversant (4, 6) dans lequel sont disposés un premier joint (14, 14'), une vanne à bille à ouverture (16, 16') et un deuxième joint (18, 18'), lesdites vannes à bille pouvant être actionnées de façon indépendante entre une position ouverte et une position fermée afin de permettre l'écoulement de liquide à travers la vanne lorsque les deux vannes à bille se trouvent à l'état ouvert, **caractérisée en ce que** lesdits premier et deuxième ensembles de vanne à bille comprennent en outre des composants d'un dispositif de retenue à ouverture (20, 20') insérés de façon verrouillante dans chaque ensemble afin de retenir la vanne à bille, ainsi que les premier et deuxième joints dans chaque ensemble, et **en ce que** les ensembles sont raccordés ensemble afin de s'accoupler l'un à l'autre au niveau de leurs passages respectifs, essentiellement dans un axe d'alignement, dans le but de former la vanne avec un raccord unique seulement (42).
2. Vanne (2), selon la revendication 1, **caractérisée en ce que** les passages (4, 6), de chacun desdits premier et deuxième ensembles de vanne à bille (10, 12) possèdent deux diamètres différents, le diamètre du passage situé à l'une des extrémités de l'ensemble étant inférieur au diamètre du passage situé à l'autre extrémité de celui-ci, les passages ayant le diamètre le plus grand se trouvant dans la zone de l'extrémité des ensembles qui sont amenés en contact d'accouplement.
3. Vanne (2), selon la revendication 2, **caractérisée en ce que** le premier joint (14, 14') et le deuxième joint (18, 18') de chaque ensemble de vanne à bille (10, 12) ont essentiellement une forme annulaire.
4. Vanne (2), selon l'une quelconque des revendications précédentes, **caractérisée en ce que** chacun desdits premier et deuxième ensembles de vanne (10, 12) est muni d'une surface d'accouplement essentiellement plane.
5. Vanne (2), selon la revendication 4, **caractérisée en ce que** le composant du dispositif de retenue à ouverture (20, 20') se trouve essentiellement au même niveau que les surfaces d'accouplement des premier et deuxième ensembles de vanne, après son insertion complète.
6. Vanne (2), selon l'une quelconque des revendications précédentes, **caractérisée en ce que** le composant du dispositif de retenue (20, 20') est muni de filetages et est vissé dans les filets correspondants (21) prévus dans les extrémités plus larges des passages desdits premier et deuxième ensembles de vanne à bille.
7. Vanne (2), selon l'une quelconque des revendications précédentes, **caractérisée en ce que** la vanne est munie d'un joint continu (38) qui entoure les composants du dispositif de retenue de la vanne dans la zone du raccord unique (42).
8. Vanne (2), selon l'une quelconque des revendications précédentes, **caractérisée en ce qu'un** joint (40) est prévu dans l'une des surfaces externes de l'un au moins des composants du dispositif de retenue, ledit joint étant comprimé par la surface correspondante de l'autre composant du dispositif de retenue dans l'autre ensemble de vanne à bille, au fur et à mesure que les deux ensembles de vanne se rapprochent l'un de l'autre, empêchant ainsi tout liquide de s'échapper à travers le raccord.
9. Vanne (2), selon la revendication 8, **caractérisée en ce que** ledit joint (40) est réalisé dans un matériau flexible qui résiste par friction au mouvement relatif des dispositifs de retenue situés dans la vanne, lorsqu'il se trouve à l'état comprimé.
10. Vanne (2), selon l'une quelconque des revendications précédentes, dans laquelle chacun desdits premier et deuxième ensembles de vanne à bille (10, 12) comprend un moyen d'actionnement (30) connecté à une tige (26) munie d'une garniture (28) qui est insérée dans l'ensemble et qui permet de déplacer la vanne à bille (16, 16') entre la position ouverte et la position fermée.
11. Vanne (2), selon la revendication 10, **caractérisée en ce qu'une** vis (32) de blocage à tête en forme de came est prévue contre un méplat de la tige (26) ou contre un méplat d'un écrou retenant ladite tige (26) et/ou la garniture (28) afin d'empêcher tout enlèvement accidentel de la tige ou de la garniture, ou tout desserrement de ceux-ci, en raison des vibrations ou de toute autre cause.
12. Vanne (2), selon les revendications 10 et 11, **caractérisée en ce que** la garniture (28) est une garniture de type à faibles émissions, par exemple Enviroflex®.



13. Vanne (2), selon l'une quelconque des revendications précédentes, **caractérisée en ce qu'un ensemble d'évent (14") est connecté à l'intérieur de la vanne en communication avec le passage (4) entre les vannes à bille (16, 16') des premier et deuxième ensembles de vanne à bille (10, 12).** 5
14. Vanne (2), selon la revendication 13, **caractérisée en ce que l'ensemble d'évent (14") fait partie intégrante de l'un des ensembles de vanne à bille (10, 12).** 10
15. Vanne (2), selon la revendication 13, **caractérisée en ce que l'ensemble d'évent (14") est positionné dans un élément qui est inséré de façon à se trouver entre les ensembles de vanne à bille (10, 12) lorsqu'ils sont raccordés pour constituer la vanne.** 15
16. Vanne (2), selon la revendication 13, **caractérisée en ce que l'ensemble d'évent (14") peut être raccordé à l'une de plusieurs ouvertures (5) pratiquées dans la paroi du passage.** 20
17. Vanne (2), selon la revendication 16, **caractérisée en ce que la pluralité d'ouvertures (5) dans la paroi du passage communiquent toutes avec l'évent par l'intermédiaire d'une chambre commune sur laquelle toutes les ouvertures donnent.** 25
18. Vanne (2), selon l'une quelconque des revendications précédentes, **caractérisée en ce qu'un moyen de verrouillage (40) est situé entre les faces d'extrémité des dispositifs de retenue des ensembles de vanne respectifs, lorsque la vanne est assemblée, ledit moyen de verrouillage empêchant tout mouvement relatif des dispositifs de retenue à l'intérieur de la vanne.** 30
19. Vanne (2), selon la revendication 18, **caractérisée en ce que le moyen de verrouillage (40) est une bague qui est réalisé dans un matériau qui, de préférence, aura un degré d'élasticité plus élevé que le joint du corps (38), de façon à permettre la compression du moyen de verrouillage avant le joint du corps, et par conséquent agit comme un moyen destiné à absorber les forces de vibration ou toute autre force s'exerçant sur les dispositifs de retenue (20, 20') pour obliger ceux-ci à changer leur position dans la vanne.** 35
20. Méthode d'assemblage d'une vanne à double isolement (2), telle qu'elle a été définie dans la revendication 1, ladite méthode comprenant les étapes suivantes : formage d'un premier ensemble de vanne à bille (10) par le formage d'un corps ayant un passage (4A), dont l'une des extrémités présente un diamètre suffisant (4A') pour permettre le déplacement des composants de la vanne (14, 16, 18) 40

dans le passage (4A), l'insertion desdits composants qui comprennent un premier joint (14), une vanne à bille à ouverture (16) et un deuxième joint (18), l'insertion d'un dispositif de retenue à ouverture (20) destiné à retenir les composants de la vanne à l'intérieur de l'ensemble, l'engagement de la bille (16) avec le moyen d'actionnement (30, 26, 28) afin de permettre le mouvement de la bille entre la position Ouverte et Fermée, la répétition du processus dans le but de former un deuxième ensemble de vanne à bille (12), le rapprochement des ensembles l'un vers l'autre de sorte que les faces d'extrémité dans lesquelles les dispositifs de retenue sont logés soient adjacentes, et que les passages pratiqués dans les ensembles respectifs soient alignés, et le raccordement des ensembles l'un avec l'autre afin de former la vanne avec un raccord unique seulement.

21. Méthode, selon la revendication 20, **caractérisée en ce qu'un agencement d'évent (14) est monté sur l'un ou sur l'autre des ensembles (10, 12) ou sur un élément qui est positionné entre lesdits ensembles quand ils sont engagés.** 45



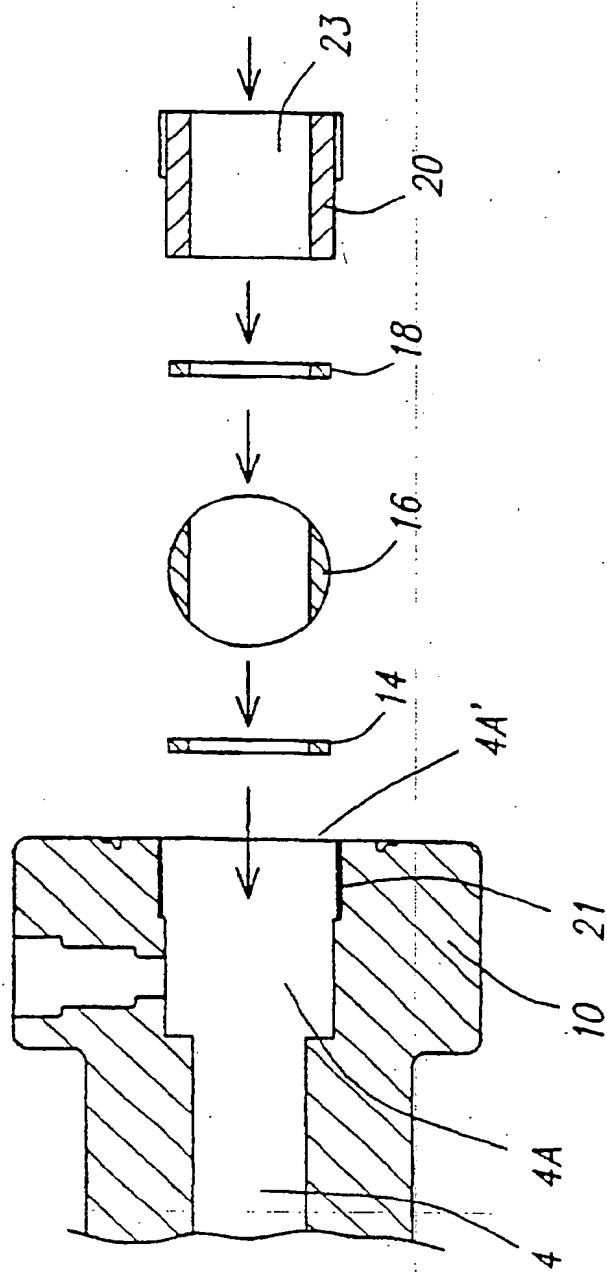


FIG. 2

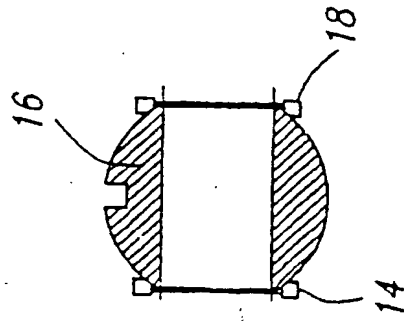


FIG. 3D

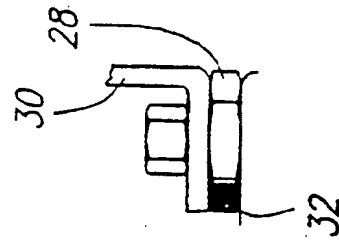


FIG. 3C

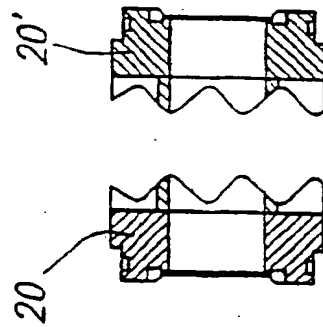


FIG. 3B

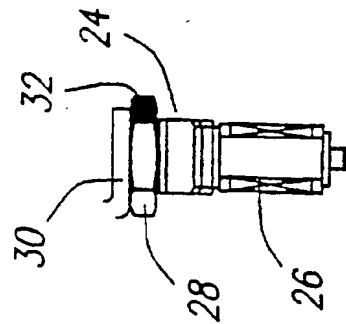


FIG. 3A

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